

Metaloc S-5

Bonding Agent for Silicone Rubber to Metals and Fabrics

METALOC S-5 is an adhesive used for bonding unvulcanized Silicone-elastomer to metals, stainless steel, fibers or other rigid substrates. The bond formed with **METALOC S-5** has superior resistance to oils, heat and corrosive atmospheres.

TYPICAL PROPERTIES

Color	: Colorless or pale yellow
Composition	: A solution composed of synthetic organic silicones in a Methanol solvent system
Reactive material	: 9-11 %
Specific gravity	: 0.83 Mg/m ³
Flash point	: 11.1°C
Diluents	: Methanol or Ethanol
Shelf life	: One year

APPLICATION AND HANDLING

Proper cleaning of the substrates is an important factor in the bonding operation. The metallic or non-metallic substrate must be cleaned of all oils, grease, rust, scale, dirt or other contaminants by suitable mechanical or chemical methods.

METALOC S-5 may be applied to metals by **brushing, spraying or dipping**. It can be brushed full strength and may be thinned with Methanol or Ethanol for dipping or spraying. With reasonable care, 1 Kg of **METALOC S-5** will cover approximately 100-200 m². Do not return used adhesive to original container. The adhesive may be colored by adding 0.1% by weight of powdered Phenol Red or Methylene Blue dyes.

METALOC S-5 should dry for at least 20-60 minutes at room temperature before bonding. The coated parts should be used within 7 days. They should be given another coat of adhesive if they are not used within this time period. For good bonding, prebaking of the adhesive is desirable. **METALOC S-5** will resist prebaking conditions same tost1 cure times and temperature.

METALOC S-5 will bond elastomers during the curing process by most commonly used vulcanizing techniques.

CAUTION

Contains volatile solvents. Keep away from heat, sparks or open flame. Use adequate ventilation. Avoid prolonged breathing of vapors and mists. Avoid contact with skin, eyes and clothing. Do not take internally.